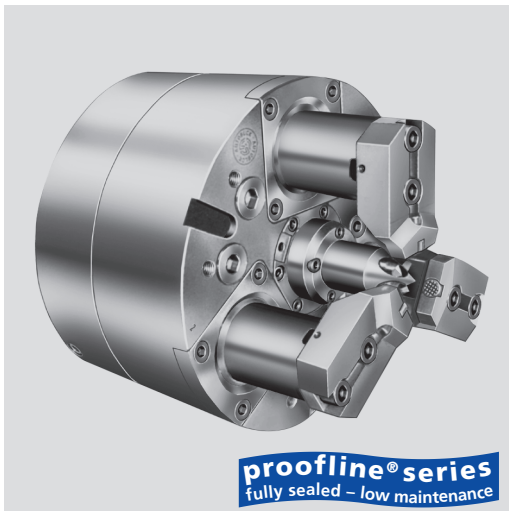


- Compensating jaw clamping
- Face driver with fixed or spring loaded center
- proofline® chucks = fully sealed – low maintenance



### Application/customer benefits

- Complete machining of shafts in one operation
- The rough machining is done with compensating jaws clamping
- Finish machining of the complete outline with the face driver at retracted jaws

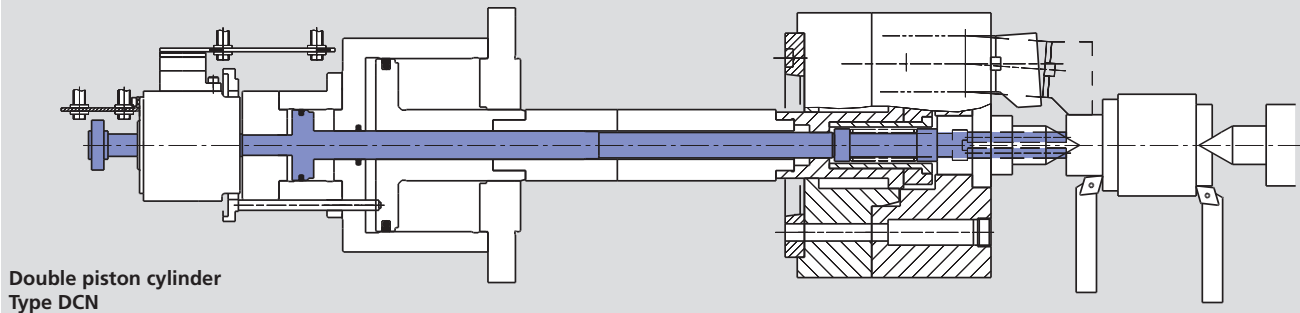
### Technical features

- Retractable jaws
- Compensating jaws clamping
- Face driver adjustable with adjusting wedges
- Center point fixed or spring loaded
- Pull down of the workpiece to the axial reference, ensures high position accuracy
- Case hardened internal parts
- Constant grease lubrication
- **proofline® chucks** = fully sealed – low maintenance

### Standard equipment

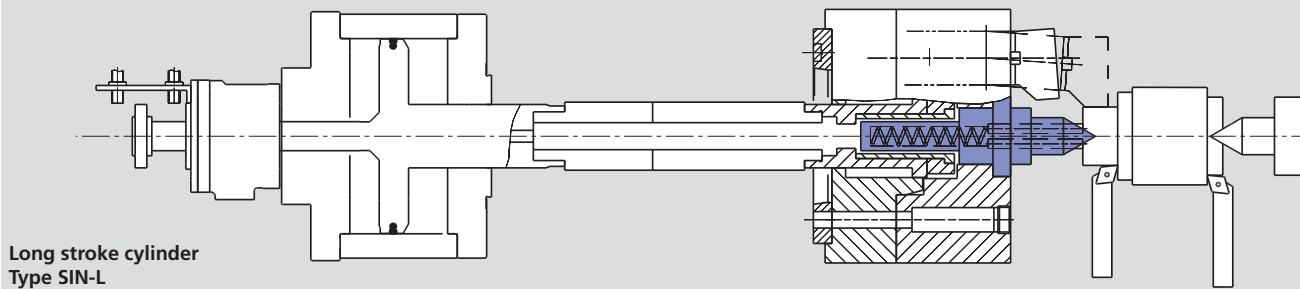
Shaft chuck without face driver  
with mounting bolts

### Axial reference in the center point - power operated face driver Actuation via double piston cylinder type ZHVD-SZ or DCN



Double piston cylinder  
Type DCN

### Axial reference on the component face - spring operated face driver Actuation via long stroke cylinder type SIN-L



Long stroke cylinder  
Type SIN-L

### Technical data

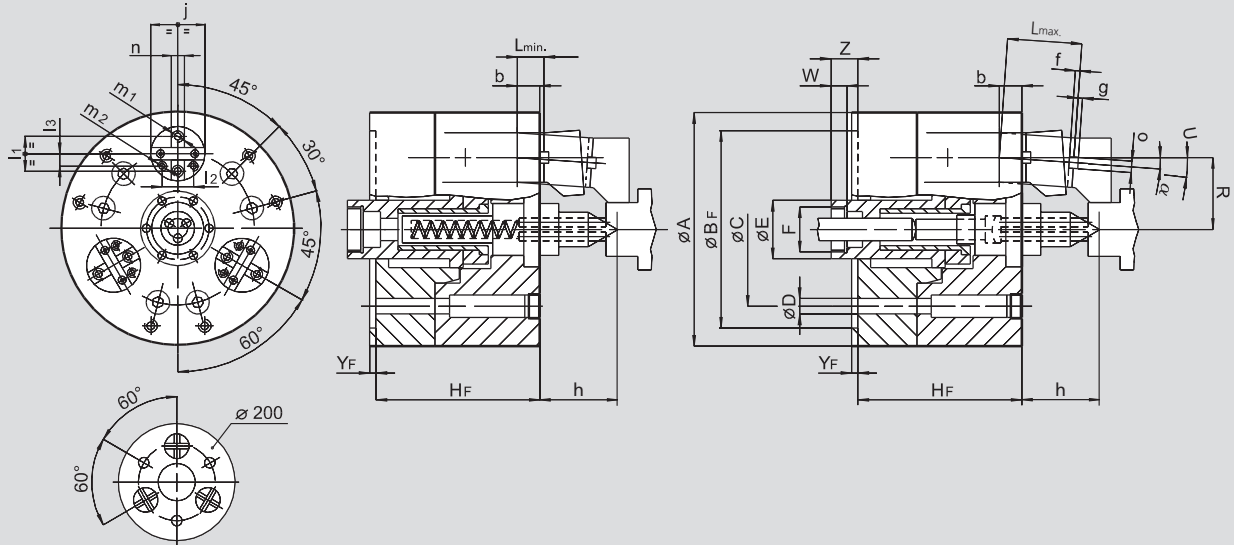
SMW-AUTOBLOK Type		GSA 200	GSA 260	GSA 320	GSA 480
Number of jaws		3	3	3	3
Angular jaw stroke U°	deg.	5°	5°	5°	5°
Radial jaw stroke at distance h	mm	9	10	11.5	15
Compensation at distance h	mm	±0.8	±1	±1	±4.5
Wedge stroke (total)	mm	57.5	66.5	77.6	103.9
Max. draw-push	kN	40	60	80	200
Max. gripping force at distance h	kN	40	65	100	240
Max. speed	r.p.m.	4500	4000	3200	1600
Weight (without top jaws)	kg	30	55	100	420
Moment of inertia	kg·m <sup>2</sup>	0.15	0.46	1.28	11
Recommended actuating cylinders: - Axial reference in the center bore		DCN 125 / 30 70 / 25	DCN 125 / 30 70 / 25	DCN 125 / 30 87 / 40 DCN 170 / 40 95 / 50	ZHVD-SZ 240-40
- Axial reference on the component face		SIN-L 125	SIN-L 150	SIN-L 150	SIN-L 250

# Shaft turning chuck $\varnothing$ 200 - 480 mm

# GSA

- Compensating jaw clamping
- Face driver with fixed or spring loaded center
- proofline® chucks = fully sealed – low maintenance

Shaft chuck with retractable jaw  
Face driver



Subject to technical changes.  
For more detailed information please ask our customer service.

4

SMW-AUTOBLOK Type			GSA 200	GSA 260	GSA 320	GSA 480
	<b>A</b>	mm	200	260	320	480
	<b>BF H6</b>	mm	170	220	280	380
	<b>C</b>	mm	146	171.4	235	330.2
	<b>D</b>	mm	17	17	21	25
	<b>E</b>	mm	50	61	75	105
	<b>F</b>	mm	M38 x 1.5	M50 x 1.5	M56 x 2	M75 x 2
	<b>HF</b>	mm	160	183	215	356
	<b>Lmin.</b>	mm	24	25	33	55
	<b>max.</b>	mm	74	83	98	135
	<b>R</b>	mm	60	75	102.5	153
Jaw pivoting	<b>U</b>	deg.	5°	5°	5°	5°
	<b>W</b>	mm	18	18	18	30
	<b>YF</b>	mm	6	6	6	18
Min.	<b>Z</b>	mm	25	27	15.4	27
Max.	<b>Z</b>	mm	82.5	93.5	93	131
	<b>b</b>	mm	24	25	32	58
	<b>f</b>	mm	4	5	5	7
	<b>g</b>	mm	3	3.5	3	6
Reference distance	<b>h</b>	mm	80	90	105	115
	<b>j</b>	mm	48	55	65	95
	<b>l1</b>	mm	32	35	42	66
	<b>l2</b>	mm	27	32	35	53
	<b>l3</b>	mm	12	12.5	16	25
	<b>m1</b>	mm	M10	M12	M16	M16
	<b>m2</b>	mm	M8	M10	M12	M16
	<b>n H7</b>	mm	12.68	12.68	12.68	19.03
	<b>o h7</b>	mm	12.68	12.68	12.68	19.03
	<b>α</b>	deg.	3.5°	3.5°	3.5°	3.5°

## ISO-A flanges for GSA chucks

	FF 1 Direct ISO-A mounting	FF 2 Reduction ISO-A mounting	FF 3 Increase ISO-A mounting	GSA chuck	Spindle	Type	Id. No.	A	BF	BA	C	C1	T
				200	A5	2	24152050	-	170	82.563	104.8	146	24
				200	A6	2	24162050	-	170	106.375	133.4	146	24
				200	A8	3	24182050	210	170	139.719	171.4	146	40
				260	A6	2	24162530	-	220	106.375	133.4	171.4	24
				260	A8	1	24182500	-	220	139.719	171.4	-	19
				260	A11	3	24112510	280	220	196.869	235	171.4	45
				320	A8	2	24183500	-	280	139.719	171.4	235	30
				320	A11	1	24113500	-	280	196.869	235	-	21
				480	A11	2	24115000	-	380	196.869	235	330.2	40
				480	A15	1	24125000	-	380	285.775	330.2	-	23



SMW-AUTOBLOK  
297